

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9347	REV. A SHEET 1 OF 1
DATE 06.08.23		TITLE STEP ARM WELD REPAIR	SCALE NTS
A	06.08.23	NEW ISSUE	

DART SERVICE INSTRUCTION

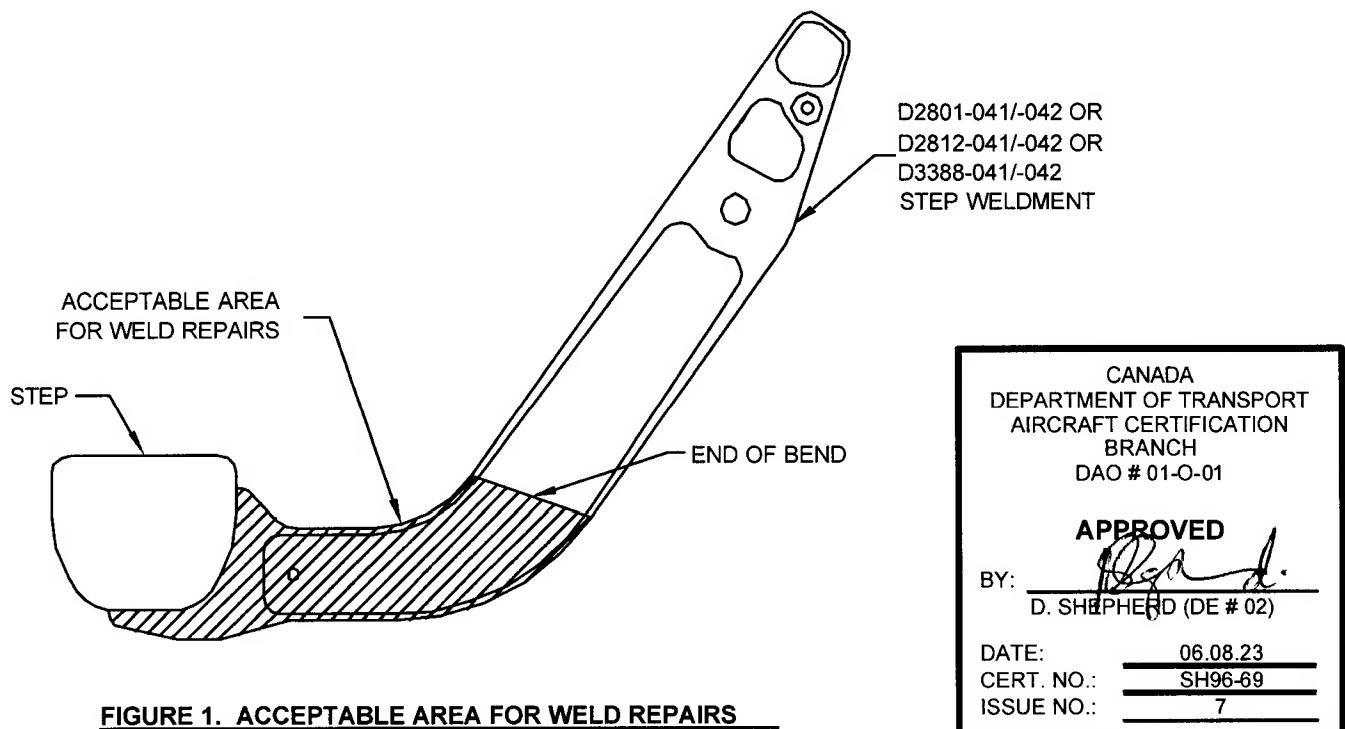
TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-630 REV 0 OR 1

REF. CANADIAN STC: SH96-69

REF. FAA STC SR00595NY / SR00597NY / SR00598NY

CRACKS UP TO 0.375" IN LENGTH IN SHADED REGION OF D2801-041/-042, D2812-041/-042 AND D3388-041/-042 STEP WELDMENTS (SEE FIGURE 1 BELOW) CAN BE REPAIRED AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC.
- 2) GRIND A CHAMFER 0.125" X 45° ALONG THE CRACK.
- 3) T.I.G. WELD CHAMFER PER MIL-STD-2219 / AMS-STD-2219 CLASS 'C' USING 4043 OR 5356 FILLER ROD.
- 4) BLEND WELD TO SAME PROFILE AS ORIGINAL PART.
- 5) LIQUID PENETRANT INSPECT PER ASTM 1417 LEVEL 2 (MINIMUM). NO CRACKS OR POROSITY INDICATORS ALLOWED.
- 6) TOUCH UP FINISH IN ACCORDANCE WITH ICA-D412-630 REV 0 OR 1.



Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.